

Date: Wednesday, 1/23/2008 12:06:56 PM
 User: Kim Johnston

Process Sheet

5

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH MODIFICATION KIT (AFT & SIDE DOOR)
Job Number	: 36945		
Estimate Number	: 12006		
P.O. Number	:	Part Number	: DSI 9189011
This Issue	: 1/23/2008 S.O. No. :	Drawing Number	: DSI 9189 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : PURCHASED PARTS	Drawing Revision	: A
Previous Run	: 25905	Material	:
Written By	:	Due Date	: 1/30/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>AS 08 01 23</u>		
Comment	: Est. A 00.06.26 New Issue EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
-----	----	------------------



Comment: DOCUMENT CONTROL
 Provide photocopy of DSI 9189

chg 001

KS 08 01.23
 Blue files Credited Labels per
 PPP DSI 9189 01/25

2.0	D24630025	Neoprene Seal
-----	-----------	---------------



D2463

2008/02/25



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
 Neoprene Seal

Pick:

Qty	Part number	Description
2	D2463-0025	Neoprene seal

Batch

36852

New Bot

AS 08/02/25 (x4)

3.0	D2585	Latch Clamp
-----	-------	-------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Latch Clamp

Pick:

Qty	Part number	Description	Batch
2	D2585	Mouting channel	360020

AS 08/02/25 (x4)

4.0	D2586	Door Latch
-----	-------	------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Door Latch

Pick:

Qty	Part number	Description	Batch
2	D2586	Latch	B35802

AS 08/02/25 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH MODIFICATION KIT (AFT & SIDE DOOR)

Job Number: 36945

Part Number: DSI 9189011

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2621

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Latch Plate

Pick:

Qty	Part number	Description	Batch
2	D2621	Latch plate	B32355

AS 08/02/25 (x4)

6.0

D2980

Latch Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Latch Plate

Pick:

Qty	Part number	Description	Batch
2	D2980	Latch plate	12691

AS 08/02/25 (x4)

7.0

D2589

Keys, Key Chain



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Keys, Key Chain

Pick:

Qty	Part number	Description	Batch
1	D2589	Keys, key chain	31887

AS 08/02/25 (x4)

8.0

AN960JD10

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Pick:

Qty	Part number	Description	Batch
2	AN960JD10	Washer	106167

AS 08/02/25 (x4)

9.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Nut

Pick:

Qty	Part number	Description	Batch
2	MS21042-3	Nut (or L3)	M106242

AS 08/02/25 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 9/10/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/23/2008 12:06:57 PM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH MODIFICATION KIT (AFT & SIDE DOOR)

Job Number: 36945

Part Number: DSI 9189011

Job Number:



Seq. #:

Machine Or Operation:

Description :

10.0

MS27039118

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Screw

Pick:

Qty

Part number

Description

Batch

2

MS27039-1-18

Screw

M102339

AS 08/02/25

(XV)

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Draft

8h/25

54

(4)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AD 08/02/25

Job Completion



2008/2/25

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. DSI 9189	REV. A SHEET 1 OF 3
DATE 00.05.23		TITLE AFT AND SIDE DOOR LATCH MOD.	SCALE NTS
A	00.05.23	NEW ISSUE	

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION DRAWINGS: D350-588 REV. A OR EARLIER
D350-589 REV. A OR EARLIER

REF. CANADIAN STC: SH92-41
US FAA STC: SH1012NE

INTRODUCTION

THE PURPOSE OF THE DSI 9189-011 KIT IS TO PROVIDE THE HARDWARE TO REPLACE THE D2443 LATCHES (REF. HARTWELL PART NUMBERS H605S190A496 OR H2818-3S125A OR H605K3240) WITH D2586 LATCHES.

PART LIST

Qty -011	Part Number	Description
X	DSI 9189-011	LATCH MODIFICATION KIT
2	D2463-0025	1/2" FOAM SEAL
2	D2585	MOUNTING CHANNEL
2	D2586	LATCH
1	D2589	KEYS, KEY CHAIN
2	D2621	LATCH PLATE
2	D2980	LATCH PLATE
2	AN960JD10	WASHER
2	MS21042L3	NUT
2	MS27039-1-18	SCREW

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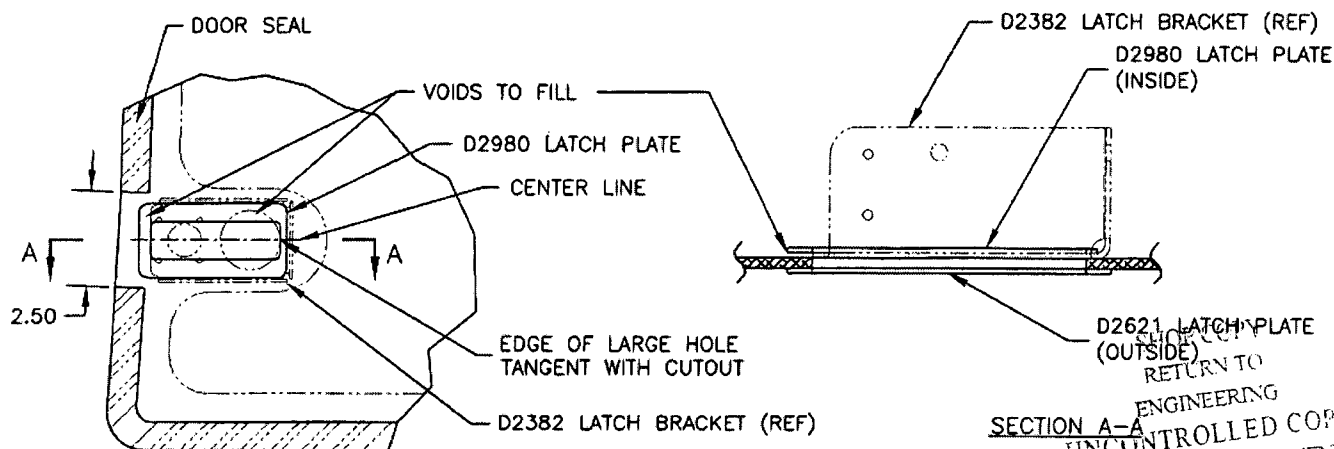
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DATE 00.05.23		TITLE AFT AND SIDE DOOR LATCH MOD.	SCALE NTS

PROCEDURE:**AT EACH LATCH LOCATION**

1. REMOVE EXISTING D2443 LATCH AND D2383 LATCH BRACKET COVER FROM THE DOOR. DO NOT REMOVE D2382 LATCH BRACKET.
2. REMOVE 2.5" (MAX) OF SEAL FROM EDGE OF THE DOOR PER FIGURE 1.
3. DRAW A LINE CONNECTING THE CENTRES OF THE TWO LARGE HOLES FOR THE EXISTING LATCHES.
4. LINE UP THE INSIDE EDGE OF THE D2980 LATCH PLATE WITH THE EDGE OF LARGER LATCH HOLE AS SHOWN IN FIGURE 1. MAKE SURE THE D2980 LATCH PLATE IS CENTERED ON THE LINE CREATED AT STEP 3.
5. USING THE D2980 LATCH PLATE AS A TEMPLATE, MARK THE CUTOUT PROFILE FOR THE LATCH.
6. CUT A HOLE IN THE DOOR PER THE PROFILE CREATED AT STEP 5. TRIM TO FIT D2586 LATCH.
7. CLEAN THE INSIDE OF D2382 AND OUTSIDE OF THE DOOR IN THE VICINITY OF THE D2621 AND D2980 LATCH PLATES WITH ACETONE.
8. INSTALL D2621 LATCH PLATE OUTSIDE AND D2980 LATCH PLATE INSIDE OF THE DOOR AS SHOWN IN SECTION A-A USING 5 MIN. EPOXY OR PRC. ENSURE THAT THE LATCH PLATES LINE UP WITH THE RECTANGULAR CUTOUT FOR THE D2586 LATCHES. CLAMP LATCH PLATES IN PLACE. FILL THE VOID BETWEEN THE D2621 AND D2980 LATCH PLATES AS SHOWN IN FIGURE 1 WITH 5 MIN. EPOXY OR PRC. WIPE AWAY EXCESS EPOXY OR PRC FROM ALL AROUND THE LATCH PLATE INSTALLATION. ALLOW AT LEAST 15 MIN. BEFORE REMOVING CLAMPS AND PROCEEDING TO THE NEXT STEP.
9. INSTALL REPLACEMENT D2463-0025 NEOPRENE SEAL OVER THE D2980 LATCH PLATE.
10. INSTALL D2586 LATCH AND D2585 MOUNTING CHANNEL PER FIGURE 2.

**FIGURE 1: TYPICAL DOOR CUTOUT**

SECTION A-A
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DATE 00.05.23	TITLE AFT AND SIDE DOOR LATCH MOD.		SCALE NTS

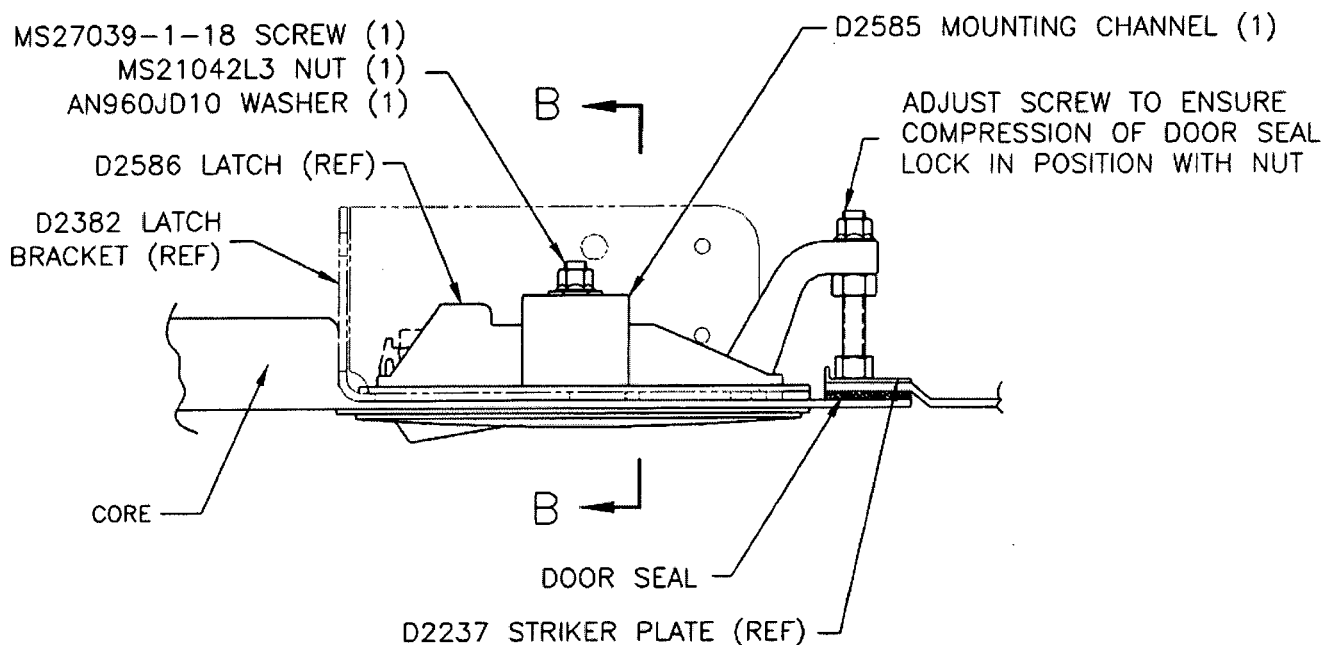
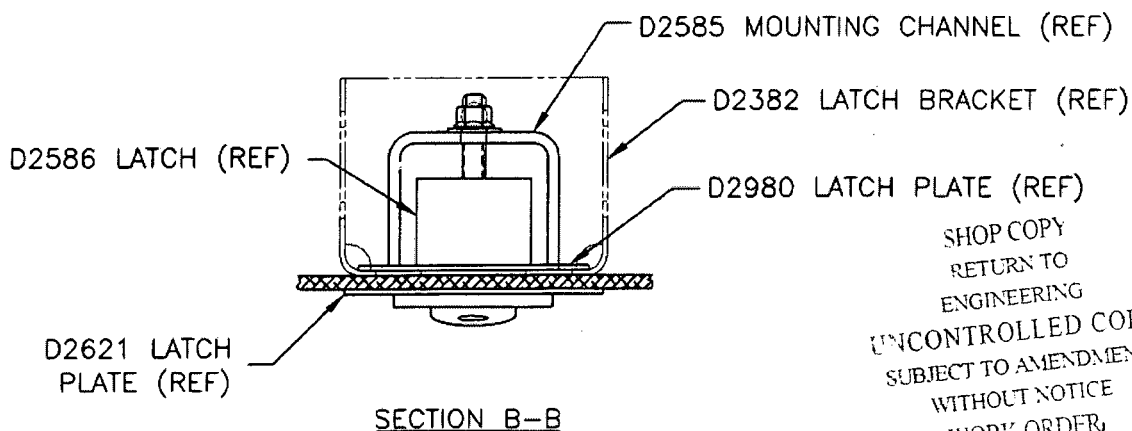


FIGURE 2: TYPICAL LATCH INSTALLATION



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